

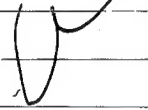
Work Order ID 86997

86997

Page 1

July-09-12 9:29:07 AM

Item ID: D4019-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Light Lid Short Basket Assembly
 Start Date: 7/09/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4019	D	

100 Weld per dwg A/R Aluminum rod Batch: M120354 0.00
 100 Large Fab
 Memo 0.00
 1- Assemble ribs, weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.
 ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****
 2- weld hinge, label plate and Mounting plates as per dwg D4019
 1x PL 12-07-09

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110 QC
 Memo 0.00
 Quality Control
1 0 BE 12-07-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86997

86997

Page 2

July-09-12 9:29:07 AM

Item ID: D4019-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/10/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch 012854	0.00							
140									
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

Handwritten notes:
 1 NG 12-7-9
 Cpl / CC 12 - 7 - 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86997

86997

Page 3

July-09-12 9:29:07 AM

Item ID: D4019-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Light Lid Short Basket Assembly
 Start Date: 7/09/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control	5 ACS _____ 78 12/07/10								
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to and mask sides of hinge prior to powdercoat								

1ST COAT: 8:45
 START TIME: 3200 F
 OVEN TEMPERATURE:
 FINISH TIME: 9:15
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME:
 OVEN TEMPERATURE:
 FINISH TIME:

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July-09-12 9:29:07 AM

Page 4

0.00

~~6~~ 624210

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86997

July-09-12 9:29:07 AM

86997

Page 5

Item ID: D4019-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Short Basket Assembly
 Start Date: 7/09/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>D4032 d43</u> Memo	0.00 0.00	85738			1	0		DL 12-7-10
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 12/07/11 MLJ 12/07/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 9:29:06 AM

Page 1

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.07 verified by:EC
verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC
as per dwg revD DD 10.08.18 verified by:EC IPP Rev:B as per dwg revA 10.03.15
IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4019-1 Rib		Manufactured	No			100	Each	2.0000	2	2		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		2							
				60974		2							
✓ D4019-3 Rib		Manufactured	No			100	Each	14.0000	2	2		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
				63667		0							
				83798		2							
				84848		4							
				86449		8							
✓ D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	9.0000	3	3		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		9							
				85937		9							
✓ D2957 Mounting Plate		Manufactured	No			100	Each	10.0000	4	4		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				84820		10							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 9:29:07 AM

Page 2

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-045 Manufactured No 100 Each 5.0000 1 1 Pl 12.07.09
Lid Rib Assembly, Fwd (Light)

Location	Loc Qty	Loc Code
WA	5	
63668	0	
74466	1	
84688	4	

✓ D4035-047 Manufactured No 100 Each 4.0000 1 1 Pl 12.07.09
Lid Rib Assembly, Aft (Light)

Location	Loc Qty	Loc Code
WA	4	
63669	0	
85936	4	

✓ D4029-043 Manufactured No 180 Each 5.0000 1 1 - JB
Webbing (Short Basket)

Location	Loc Qty	Loc Code
st503	5	
56967	5	

✓ D4056-1 Manufactured No 100 Each 2.0000 1 1 Pl 12.07.09
Label Plate

Location	Loc Qty	Loc Code
WA005	2	
84866	2	

NAS1149DN416J Purchased No 180 Each 474.0000 30 30 ✓ JB 12/07/10
Washer

Location	Loc Qty	Loc Code
ST297	474	
114597	43	
122151	400	
13910	31	

July-09-12 9:29:07 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 9:29:07 AM

Page 3

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,284.0000

30

30

Cherry Rivets

Location

Loc Qty

Loc Code

ST314

560

122151

560

ST321

591

111636

36

117601

3

118626

294

120308

258

WA018

133

107939

133

D2728-1

Manufactured

No

180

Each

0.0000

1

1

Dart Logo label

July-09-12 9:29:07 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

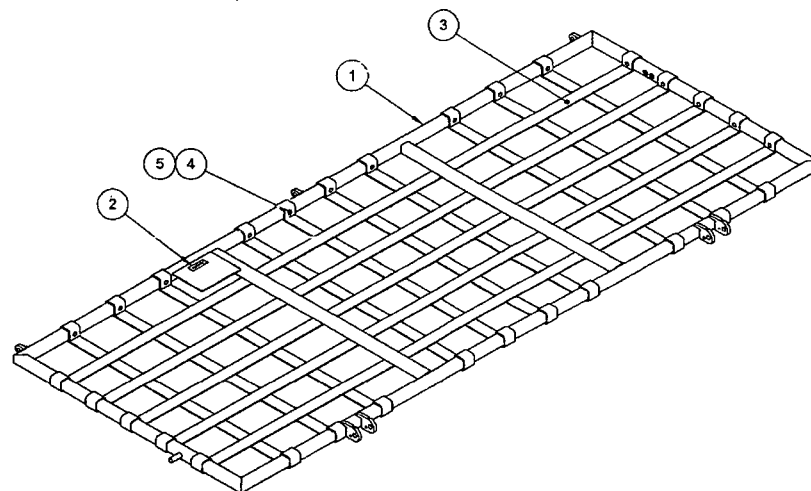
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



D4019-041 LIGHT LID SHORT BASKET ASSY

RELEASED
10.08.12
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.83 lbs

D	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-243, UPDATED VIEW E ACCORDINGLY (A7-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4WS: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2). SECTION B-B REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AKS		
DRAWN	AKS		
CHECKED	JSC		
MFG. APPR.	JSC		
APPROVED	JSC		
DE APPR.	JSC		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4019** REV. D
SHEET 1 OF 4
TITLE **LIGHT LID SHORT BASKET** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

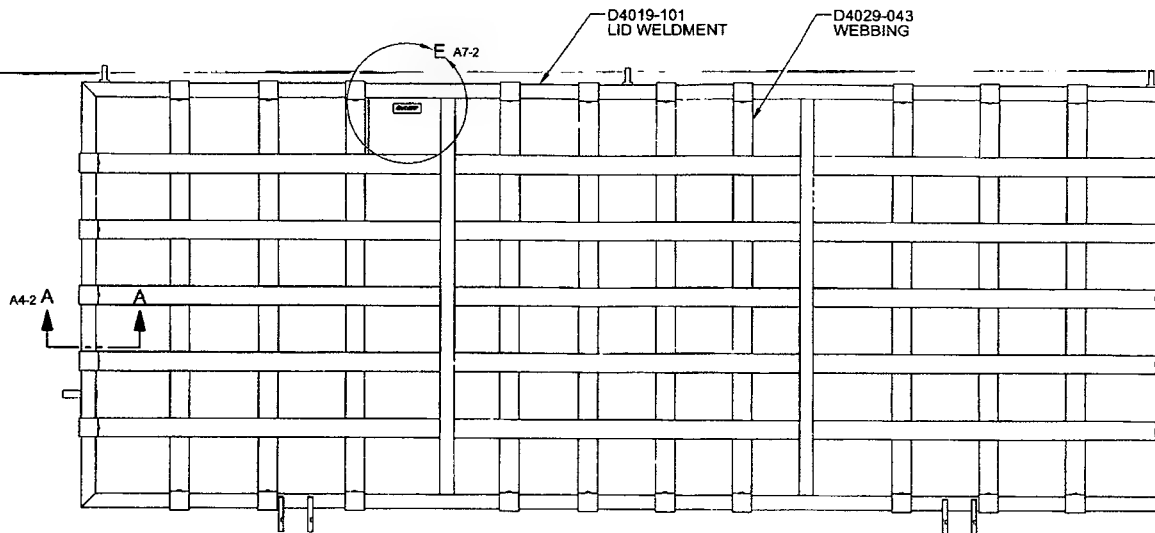
8 7 6 5 4 3 2 1

D

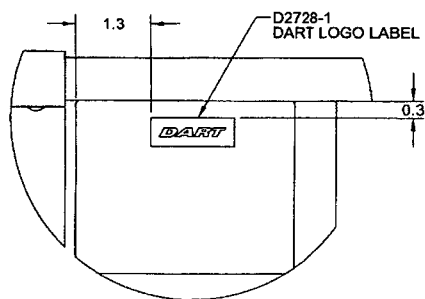
C

B

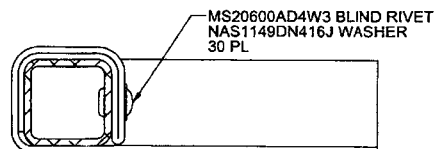
A



D4019-041 LIGHT LID SHORT BASKET ASSY



DETAIL E D5-2



SECTION A-A C7-2

RELEASED
10 DEC 12 CP

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	MS	D4019	SHEET 2 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

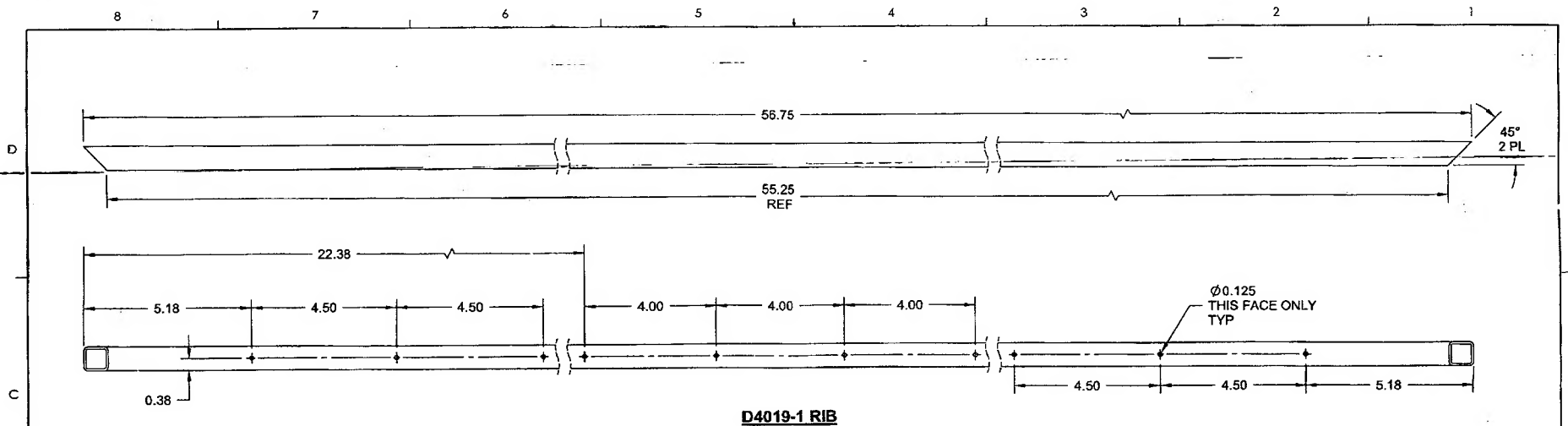
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

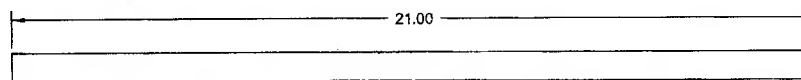
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

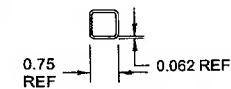
NOTE: Date & initial all entries



D4019-1 RIB



D4019-3 RIB



RELEASED
10.08.12

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 0.77 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.		D4019	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LENT FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries